

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-014274**Date Inspected:** 01-May-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Wu Chi Cheng**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Orthotropic Box Girder( OBG)**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Manoj Prabhune was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

This QA Inspector randomly observed the following work in progress:

OBG # TRIAL ASSEMBLY YARD

Segment # Lift 7

This Quality Assurance (QA) Inspector witnessed final tension verification for Lower Chevron X3D Angle and Lower & Upper Chevron Bracing (Cross Beam and Counter Weight side) at Panel Point (PP) 59 ~PP64 for Segment 7EW ~8AW. Inspected 10% on a random basis and found the tension to be in general compliance. Inspection was performed against the Notification No. 00338 Dated May 01, 2010.

Bolt sizes used were M22 x 65 RC Set# DHGM220021 and final torque required was Rotation of Nut.

Bolt sizes used were M22 x 70 RC Set# DHGM220017 and final torque required was 520 N-m.

Bolt sizes used were M22 x 75 RC Set# DHGM220034 and final torque required was 453 N-m.

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Bolt sizes used were M22 x 80 RC Set# DHGM220029 and final torque required was 447 N-m.

Manual Torque wrench was been used with Sr. No. XQ2-779.

Note: Please refer the picture for more comprehensive details.

### Segment # 7

This QA Inspector performed Individual Inspection for the WT Stiffener Offset and Buckling- FL3 Location Segment 7BW (Shop Segment Splice) between Panel Point (PP) 50 ~PP50.5,PP51~PP51.5,PP51.5~PP52 and Segment 8CW between Panel Point (PP) 68~ PP68.5, PP69 ~PP69.5, PP69.5 ~ PP70. The measured readings were fed in spread sheet, generated the report and submitted to the Task Leader and Engineer for review.

### Segment # 8BW

This QA inspector observed, ZPMC qualified welding personnel identified as 044779 perform Shielded Metal Arc Welding (SMAW), weld joint identified as CA049-054; ZPMC QC is identified as Mr. Wang Xiang Tin. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-P-4113-2.

### Segment # 8CE

This QA inspector observed, ZPMC qualified welding personnel identified as 066746 perform Flux Core Arc Welding (FCAW), weld joint identified as SSD27-PP069-138; ZPMC QC is identified as Mr.Feng Ya Jun. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2233T.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



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### Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang phone: 15000422372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Prabhune,Manoj	Quality Assurance Inspector
<b>Reviewed By:</b>	Patterson,Rodney	QA Reviewer

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